

Date: Tuesday, 4/17/2007 3:48:24 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECK PLATE KIT -UNDER REVIEW
Job Number : 31899	
Estimate Number : 11233	
P.O. Number :	Part Number : D350616015
This Issue : 4/17/2007 S.O. No. :	Drawing Number : D350-616 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D-UNDER REVIEW
Previous Run : 31411	Material :
Written By :	Due Date : 5/2/2007 Qty: 6 Um: Each
Checked & Approved By : <u>407.04.18</u>	
Comment : Est Rev:C Removed Manufacturing 05-12-05 JLM	
Est Rev:D Add D3494-1 05-12-05 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Create labels per PPP D350-616-015 CHG002

KS 07-04-18

(6)

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2344 Deck Plate, Aft, 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft)

B29143

B31918

B-31927 3P

4.0 D2348 Wear Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way)

B210901

B27736

5.0 D2353 Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener

B29145

B25275

B31920

B31920

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DECK PLATE KIT - UNDER REVIEW

Job Number: 31899

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2364

Deck Plate, Fwd 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd)

B31921 ✓

7.0

D2365

Wear Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin)

B23759 ✓

B27928 ✓

8.0

D23691

Template



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate

B23674 ✓

B23759 ✓

9.0

D23693

Template



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate

B23759 ✓

X16 ✓

10.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN960JD10 Washer

M100743 ✓

29

M103937A ✓

11.0

MS20426AD45

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet

M43459 ✓

7/5/10 SQ ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20426AD46

Rivet



Comment: Qty.: 25.0000 Each(s)/Unit Total : 150.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet

M2566 ✓

13.0

MS20426AD57

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet

M7687 ✓

14.0

MS20426AD58

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet

M4533 ✓

15.0

MS20601AD4W2

Rivet



Comment: Qty.: 15.0000 Each(s)/Unit Total : 90.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet

M102519 ✓

16.0

MS20601AD4W3

Rivet



Comment: Qty.: 30.0000 Each(s)/Unit Total : 180.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet

M8325 ✓

7/31/05 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3)

M104215 ✓

✓

18.0

MS24693C48

Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total : 132.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48)

80
M17566 ✓ M12620 ✓

✓

19.0

MS24693C273

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273 Screw (or -273)

M12620 ✓

✓

20.0

D34941

STUB COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

STUB COVER

Batch:

1528946 ✓

7/5/105⁰ (6)

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/6/5 (6)

W 270605

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location:

PPP Rev:

Dev C 7/6/5 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 31899

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

9/27/06/06

Job Completion



W 870606

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-616	REV. D SHEET 1 OF 13
DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION SCALE NTS	
A	95.02.20	NEW ISSUE	
B	96.01.09	ADD VIEW OF D2493 TO SHEET 9	
C	06.01.10	ADD DSI 9112/9117/9130/9236/9310	
D	06.01.19	ADD D3494-1 STUB COVER	

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
	1		D2350	LITTER TIE DOWN (NON-LOCKING)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
		1	D3494-1	STUB COVER
		10	AN960JD10	WASHER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (OR CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (OR CR9162-4-3)
		22	MS24693-C48	SCREW (OR MS24693-48)
		6	MS24693-C273	SCREW (OR MS24693-273)
		6	MS21042L3	NUT (OR MS21042-3)
		4	MS35207-264	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31899

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
CERT. NO.:	SH96-10
ISSUE NO.:	2

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